Work Order ID 71689 Thursday, July 07, 2011 12:54:34 PM D3537-7 Item ID: Revision ID: Wearpad Item Name: 7/7/2011 Start Date: Start Qty: 12.0

Page 1

Accept	
	Cust Item ID:

Setup Start

Required Date: Reference:	7/21/2011 Req'd Qty: 12.00			Customer:						
Approvals:	Process Plan: CX QC:	Date: ///07/07 Date:	Tooling: SPC (Y/N):		ate: ate:		F	tun Sta Sto		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								1 7	
D3537	Rev C									
100 Waterjet	FLOW WATER JET Memo		0.00				BII-	8-4		
FLOW CNC Waterje	t 1-Cut as per	Dwg D3537 Dwg Rev:	Prog Rev: (□2-						

110

QC2- Inspect parts off machine FAI/FAIB

Deburr if necessary

0.00

304.063

0.00 Memo

1311-84

Quality Control

OC

QC8- Inspect parts - second check

Quality Control

Memo

The state of the s									
W/O:		10400	WO	RK ORDER CHANGES	S	AC.			
DATE	STEP	PROC	EDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	Trib.			* 4	-3				
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	١:	_ Date: _	
	R	esolution:	Disposition	:	QA: N/C C	losed:		Date: _	A STATE OF THE STA
NCR:		W	ORK ORDE	R NON-CONFORMAN	ICE (NC	R)			4
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	B Sign Date			Approval Chief Eng	Approval QC Inspector
				e d Nei					
		Marsan, m						w 27	
2				r velori,					

Work Order ID 71689

Thursday, July 07, 2011 12:54:34 PM



Page 2

Item ID:

D3537-7

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 7/21/2011

Wearpad

7/7/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Sequence ID/

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

0.00

Set Up/

Run Hours

Tool ID

Tool # Plan

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Work Center ID 130

Brake NC

Operation

NC BRAKE

Description

Deburr if necessary Form on Brake as per Dwg D3537using Jigs DT8261 and SB (163/2)

Memo

Code

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 Dulos/23

Ensure joggle as per dwg D3429

150

Large Fab Large Fab

Large Fab

Memo

0.00

0.00

Description M/1845 3 Weld hardcoat as per Dwg D3437 2059B Hardcoat

EZ 148-24

	Carross and some contract of the contract of t									
W/O:	An Thomas	4.1	WO	RK ORDER CHAN	IGES					1.75
DATE	STEP	PRO	CEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8 % 								6	5	
Charles L										
Part No	:	PAR #:	Fault Categ	ory:	NCF	l: Yes 1	No DQ	A:	_ Date: _	
	Reso	lution:	Disposition	:	QA:	N/C Clo	sed:		Date: _	
NCR:	n i	١	WORK ORDE	R NON-CONFOR	MANCE	(NCR)			- 17 - 17	
DATE	STEP	Description of NC	-		ection B	01	Verific	ation	Approval	Approval
	01.21	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti	on C	Chief Eng	QC Inspector
					in the second		The same of			
					,					

Work Order ID 71689

Thursday, July 07, 2011 12:54:34 PM



Page 3

Item ID:

D3537-7

Accept

Setup Start

Run

Accept

Oty

Stop



Revision ID:

Item Name: Wearpad

Required Date: 7/21/2011

7/7/2011

Start Oty: 12.00 Reg'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Process Plan:

Date:

Tooling:

Date:

Tool # Plan

Code

Start



Approvals:

OC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Reject

Qty



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC10- Inspect visual per QS1004- ground welds

Memo

Memo

75/30m B wos/25

170

180

Quality Control

QC5- Inspect part completeness to step on W/O

8 11/05/75

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

START TIME:

10X y mf11/08/25

W/O:			W	ORK ORDER CHANGES					174
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	7			egory: N					
	Reso	lution:	Dispositi	on: G	A: N/C C	osed:		Date: _	
NCR:		V	VORK ORE	DER NON-CONFORMANO	CE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign 8		cation ion C	Approval Chief Eng	Approval QC Inspector
(174. <u>3</u>								Flydi.	ATTESTS OF

Work Order ID 71689

Thursday, July 07, 2011 12:54:34 PM



Page 4

Item ID:

D3537-7

Accept

Setup Start

Stop



Revision ID:

Start Date:

Wearpad Item Name:

Required Date: 7/21/2011

7/7/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Identify as per dwg & Stock Location: FP-16 0.00

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

190

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

10 BR 11-8-25

200

Packaging

Memo

0.00

Packaging

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/25 A

10 He-11-8-05

The latest the second									
W/O:			WO	RK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Hesc	olution:		ED NON CONFORMAN				Date: _	
NCR:			, Al	R NON-CONFORMAN	CE (NCF	۱)			
DATE	STEP	Description of NC		Corrective Action Section	201	Verifi	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector

Picklist Print

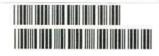
Thursday, July 07, 2011 12:54:32 PM

Work Order ID: 71689

Parent Item:

D3537-7

Parent Item Name: Wearpad



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-03-12 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	15.1000	0.15	1.894737			
										RI	+-2-4		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	15.1	
117275	1.7	
117653	13.4	
118217		

118217

W/O:	i i		WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAP	E CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						¥	9			
Part No		PAR #:	Fault Categ	ory:	NCF	R: Yes	No DQ	A:	_ Date: _	
	Reso	ollution:	Disposition		QA:	N/C CI	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC	Description of NC Corrective Action			Section B Ve			Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector
					=	d.				
									And And	
	F 1		- TURNES WITH 1844						1 2	1

DART AEROSPACE LTD	Work Order:	71689
Description: Wearpad	Part Number:	D3537-7
Inspection Dwg: D3537 Rev: C		Page 1 of 1

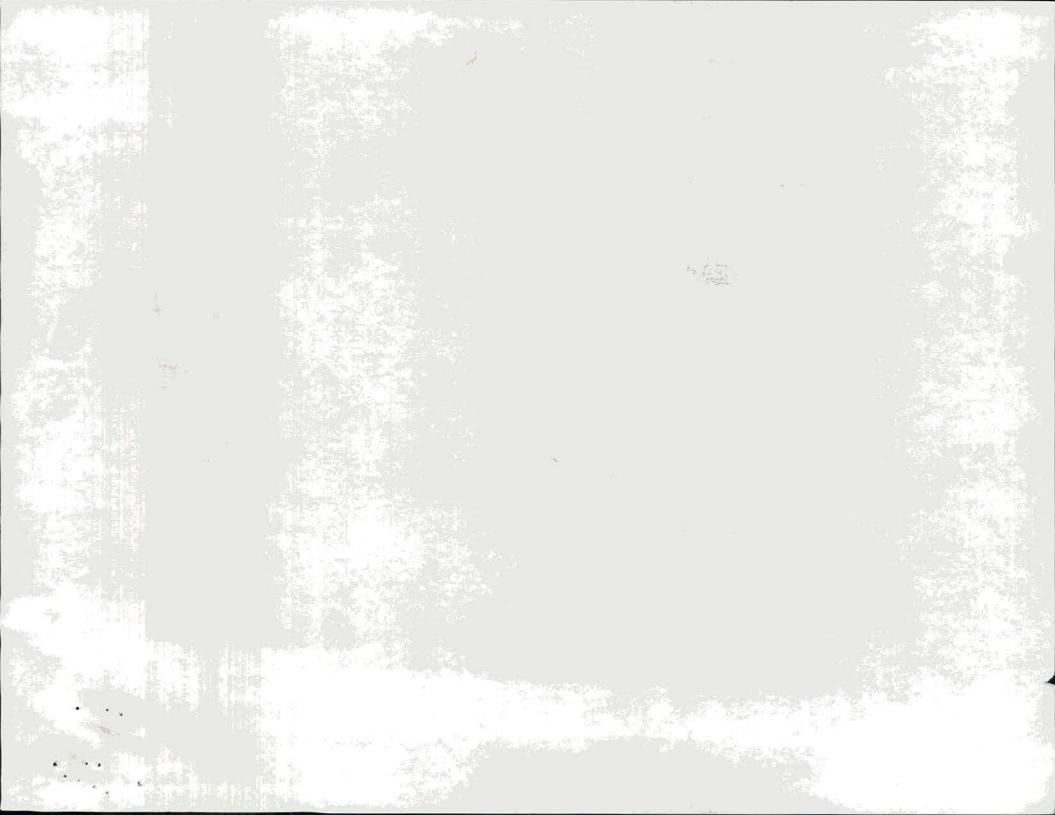
FIRST ARTICLE INSPECTION CHECKLIST

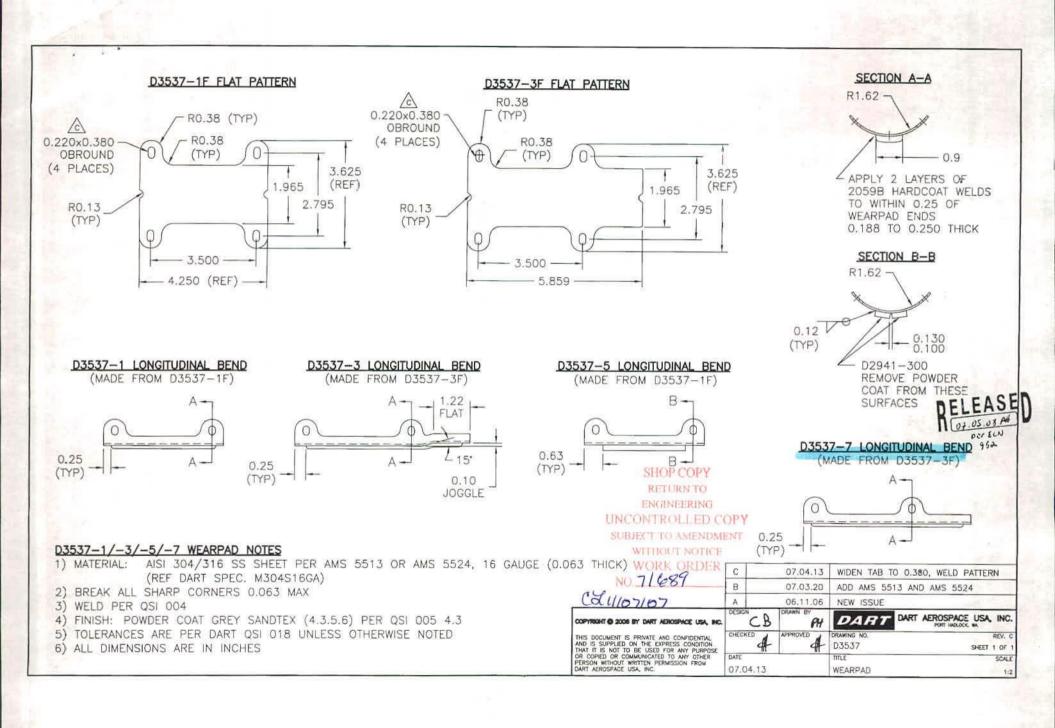
X	First Article	Prototype
-		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.859	+/-0.010	5.863	4		V BOZ	
3.500	+/-0.010	3,499	8		V	
1.965	+/-0.010	1.961	>		V	
2.795	+/-0.010	2794	10		ν	
3.625	+/-0.010	3.619	7		V	
0.220 x 0.380	+/-0.010	293× 386	>		V	
				Ŷ.		
						10.00

Measured by:	HB	Audited by:	Prototype Approval:	N/A
Date:	11-8-4	Date: 4/08/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.30	Dimensions updated per Dwg Rev B	KJ/JLM . A	N - 2 - 1
С	07.06.04	Dwg Rev updated to C	KJ/JLM C	E





-		
W. 1794		
A 1000		